HOLZ IN FORM

technical data sheet / handling instructions

Model “2567 Deep Groove II”

embossed panel from the „Holz in Form” product range

VD Werkstätten

General Definition:
The embossed panels Model “2567 Deep Groove II” from the “Holz in Form” product range are elements with special developed veneers with a plywood core.
The “2567 Deep Groove II” boards have repeating pattern.

Range of applications:
Furniture industry for facing, visible sides, fillings, covers, and so on. Interior wall and ceiling covering, sliding doors, architectural doors, et cetera.

Technical data:

Sizes:	3135x1270mm or 1270x3135 (to be defined) the first specification identifies the direction of the structure and the veneer
Thickness:	approx. 22,5mm depenting on the differences of thickness caused by the design of the model
Size accuracy :	+/- 1,0 mm per meter
Straightness:	+/- 3,0 mm per meter
Thickness allowance:	+/- 0,5 mm (please consider special features of thickness affected by the design)
Density (kg/m3)	approximately 864kg/m3 equivalent to 18,1/m² at 22,5mm thickness depending on surface composition.

Besides the allowance of +/-0.5mm of the total area thickness referring to the highest point there are minor differences in the thickness of the embossment - about 1 – 3,8mm due to the natural design specifications.

Packing:	holohedral lying on palet.
Storage:	Ample vented, dry and moisture/frost free. **The boards have to be stored holohedral reclined.** Boards with veneer should be sun-protected. **Adequate conditioning before processing is also very important.**
Processing:	**“Deep Groove II” boards, particularly the veneer coated boards need to seat solidly with at least 50% of the direct mechanical irradiated area.**
Sawing:	Use sharp hard metal sawing blades and a low sawing feed rate. Scoring is nonessential.
Milling:	Use also hard metal tools for milling and profile cutting.
Drilling:	The standard drilling tools for woodworking could be used.
Screws:	We recommend primary drilling before using screws to avoid splitting.
Gluing and bonding:	Standard wood glues and adhesives could be used. We recommend formaldehyde-free glues. If you have to raise or heighten some parts the backside **have so be** similar in composition. For example: 9mm board – 10mm carrier plate – 9mm counter draw (.35 - .39 - .35”).
Edges and lacquering:	Missing edge processing could lead to cracks in the material. **Follow absolutely our references in the brochure “Edge and Surface” development for deep and wide pattern!** Sanding after edge development. Than priming and the final lacquering. Please follow the instructions of your lacquer manufacturer. **The boards must rest holohedral – no hanging on the sides!** Lacquer always both sides! **Never use wall paint on “Holz in Form” boards!**
Attention!	If you need to encase equipment that emits heat please contact us before to avoid later damages.
Recycling:	Thermal/Energy recovery of the boards is uncomplicated (no PVC).

Explanatory notes: The given details in this data sheet are our field-tested experience. They could not consider any parameter, use case or application and they are therefore without commitment. These data does not represent guarantee of condition in the legal sense or a assurance of the characteristics. No legal claims could be derived by using the information given in these data sheets or by our free of charge technical consultants.

Please contact us about precast elements or any questions about our products.

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